

split
Work Order ID 93415-2

November-19-12 10:05:17 AM

93415

Page 1

Item ID: D3889-041

Revision ID:

Item Name: Panel, Floor

Start Date: 11/15/12 Start Qty: 2.00

Required Date: 11/30/12 Req'd Qty: 2.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: MLJ

Date: 12-11-20

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
|----------|--------------|

| | |
|-------|---|
| D3889 | A |
|-------|---|

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3889-1

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

2 0 Jm 12-11-25

2 0 Jm 12-11-25

Work Order ID 93415

November-19-12 10:05:17 AM

93415

Page 2

Item ID: D3889-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Panel, Floor
 Start Date: 11/15/12 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 11/30/12 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 120 *120* QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 0.00 | | | | 2 | | | |
| 130 *130* Small Fab Small Fab | Memo Deburr if necessary | 0.00 0.00 | | N/A SB | | | | | |
| 140 *140* Packaging Packaging | Pick Kit Memo | 0.00 0.00 | | | | 1 | | | FF 12-11-26 |

Work Order ID 93415

93415

Page 3

Item ID: D3889-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Panel, Floor

Start Date: 11/15/12 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 11/30/12 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*

QC: Date: SPC (Y/N): Date: Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

150

0.00

150

Small Fab

Memo

0.00

Small Fab

1- Bond gasket to smooth side of panel as per dwg
A/R 3M 1300 adhesive Batch: 123557

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location:

0.00

170

Packaging

Memo

0.00

Packaging

PPP
93710
92992

12/4/12 (1)

FF
12-11-26

AS
15
2-83
101127

123

Work Order ID 93415

November-19-12 10:05:17 AM

93415

Page 4

Item ID: D3889-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Panel, Floor

Start Date: 11/15/12

Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/30/12

Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00


180

QC

Memo

0.00

Quality Control

12/11/28 

12-11-27

Picklist Print

November-19-12 10:05:17 AM

Page 1

Work Order ID: 93415

Parent Item: D3889-041

Parent Item Name: Panel, Floor

Start Date: 11/15/12

Required Date: 11/30/12

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

MLEXS.125-F60029-04
GE PLASTICS LEXAN SHEET

Purchased No

100

sf

734.5384

8.1925

17.247368
17.3

Jm 12-11-21

Location

Loc Qty

Loc Code

MAT018

734.5384

121803

734.5384

121803

D3889-3

Manufactured No

140

Each

2.0000

1 2

FF 12-11-26

Gasket

Location

Loc Qty

Loc Code

ST416

2

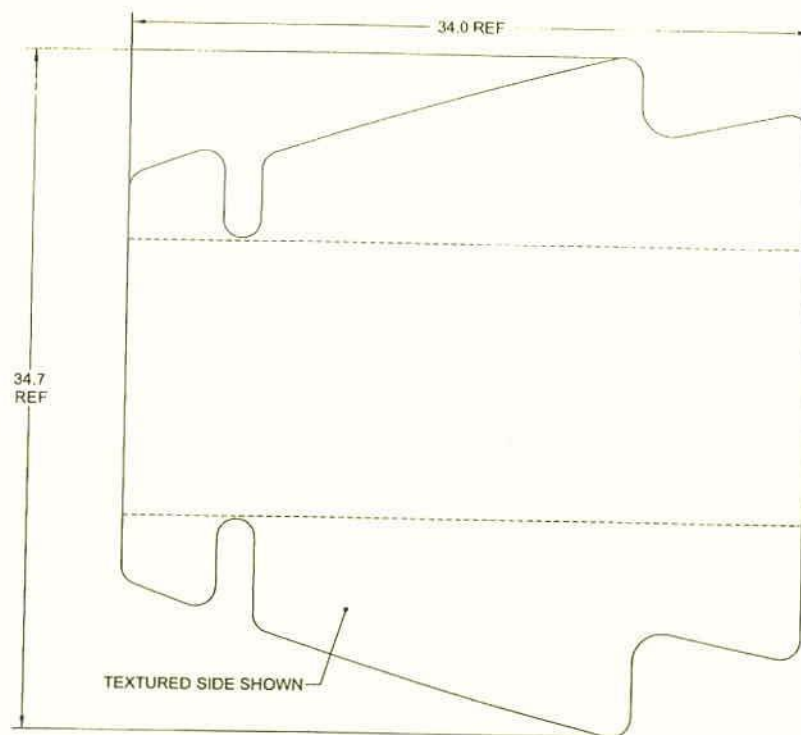
86428

2

1

PARTS LIST

| ITEM | QTY | P/N | DESCRIPTION |
|------|-----------|-----------|--------------|
| 1 | -041 X | D3889-041 | PANEL, FLOOR |
| 2 | 1 | D3889-1 | PANEL |
| 3 | 1 | D3889-3 | GASKET |
| 4 | A/R | 3M 1300 | ADHESIVE |

**D3889-041 PANEL, FLOOR**

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3889-041" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 5.13 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.

D3889-1 PANEL

D3889-3 GASKET

8

STUDY
BY
PROJ.
UNCONTROLLED

SUBMITTAL

W/REVISION

W/REVISION

NO 93415 M05
12-11-20

RELEASED
9/6/16 M/P

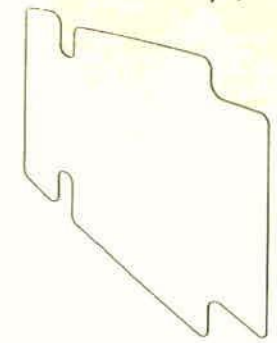
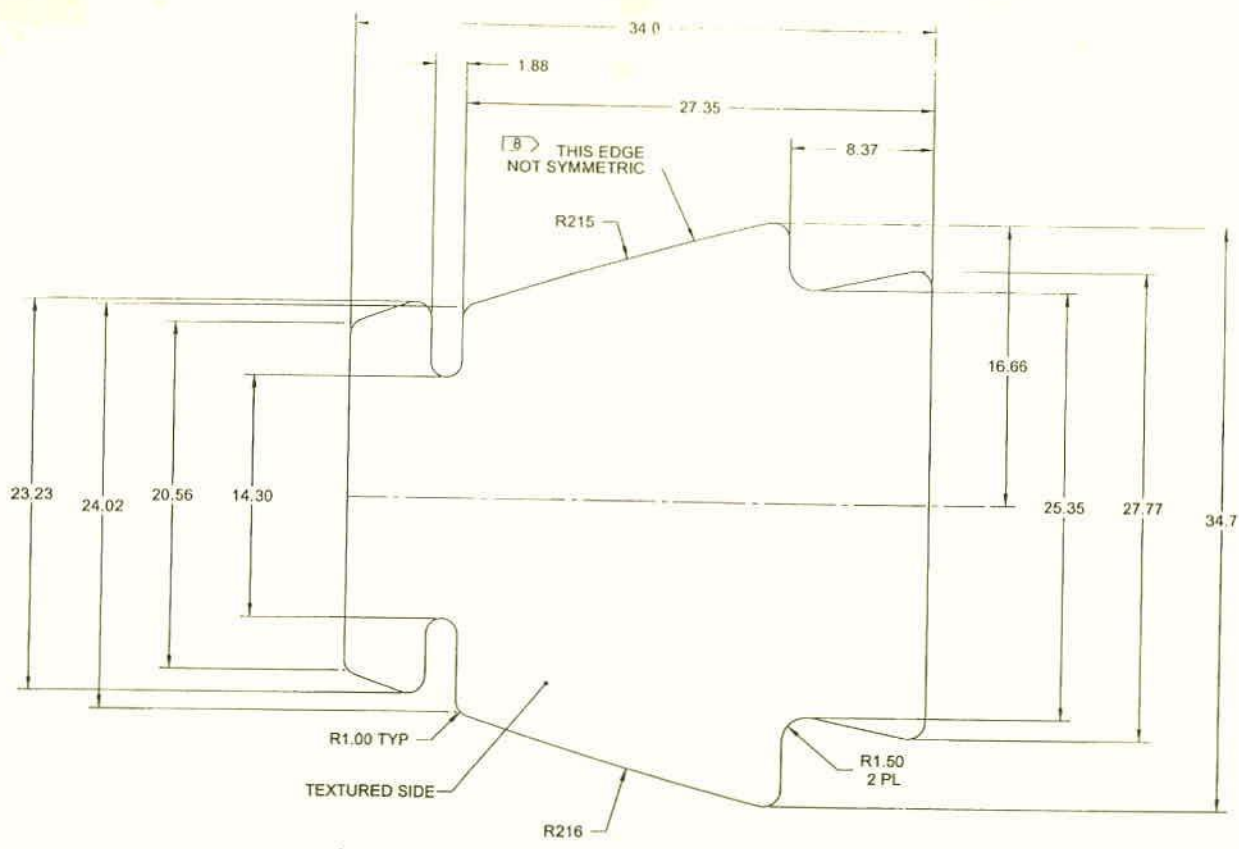
| REV. | NEW ISSUE | DESCRIPTION | CP | 09.04.20 |
|------------|-----------|-------------|----|----------|
| DESIGN | | | BY | DATE |
| DRAWN | | | | |
| CHECKED | | | | |
| MFG. APPR. | | | | |
| APPROVED | | | | |
| DE APPR. | | | | |
| DATE | 09.04.20 | | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3889
REV. A
SHEET 1 OF 3
SCALE NTS

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93415



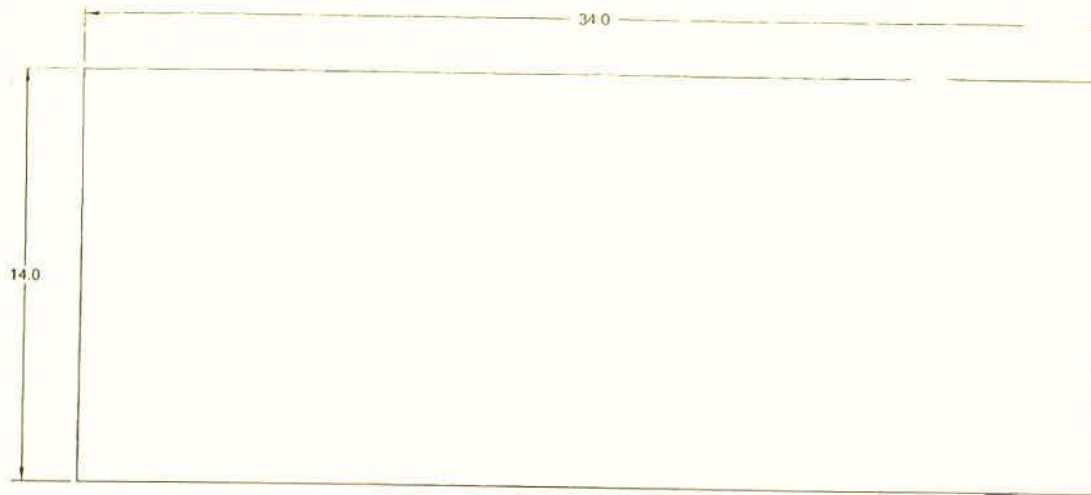
D3889-1 PANEL

- NOTES:**
- 1) MATERIAL: F60029 GY3778 LEXAN SHEET (HEAVY HAIRCELL TEXTURE, DARK GREY), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC. MLEXX.125-F60029-04)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 4.95 lbs
 - 8) PART SYMMETRIC ABOUT CENTERLINE EXCEPT AS SHOWN

RELEASED
09/04/20

| | | | |
|------------|----------|--|--------------|
| DESIGN | 93 | DART AEROSPACE LTD | |
| DRAWN | 93 | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | 93 | DRAWING NO. | REV. A |
| MFG. APPR. | 93 | D3889 | SHEET 2 OF 3 |
| APPROVED | 93 | TITLE | SCALE |
| DE APPR. | 93 | PANEL, FLOOR | NTS |
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93415



D3889-3 GASKET

RELEASED
09/06/16 JWP

NOTES:

- 1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK
(REF DART SPEC. M4111N-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs

| | | | |
|------------|----------|--|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3889 | SHEET 3 OF 3 |
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